

Date: Wednesday, 20/08/2008 12:49:00 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MAIN BODY
Job Number :	41526		
Estimate Number :	10446		
P.O. Number :		Part Number :	D33721
This Issue :	20/08/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3372 REV B
First Issue :	/ /	Project Number :	N/A
Previous Run :	22289	Drawing Revision :	B
	Type :	Material :	
	MACHINED PARTS	Due Date :	03/09/2008
Written By :		Qty:	6
Checked & Approved By :		Um:	Each
Comment :	Est. A 05.01.18 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B3000X01500	6061-T6 Bar 3.00 x 1.50
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Comment: Qty.: 0.9254 f(s)/Unit Total : 5.5522 f(s)
 Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8)
 (M6061T6B3.000x01.500)
 Identify for D3372-1
 Batch: M109058

SS 08/08/29 (5)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blank: 1.500" x 3.000" x 4.450" long

SS 08/08/29 (6)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine D3372-1 as per Folio FA496 and Dwg D3372
 Identify as D3372-1
 Deburr

H.A 08/08/30

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A 08/08/30

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 08/09/02 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 20/08/2008 12:49:00 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MAIN BODY

Job Number: 41526

Part Number: D33721

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

YL

08-09-03

(X6)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

Mask all holes

(6)

START TIME:

8:30

OVEN TEMPERATURE:

320°

FINISH TIME:

9:00

FL 08/09/05

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L

08/09/05

(GX)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FL 08/09/05

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/05

Job Completion



MF 08-09-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED [Signature]	DRAWING NO. D3372	REV. B SHEET 4 OF 8
DATE 05.02.23	TITLE COLLECTIVE LOCK		SCALE 1:2

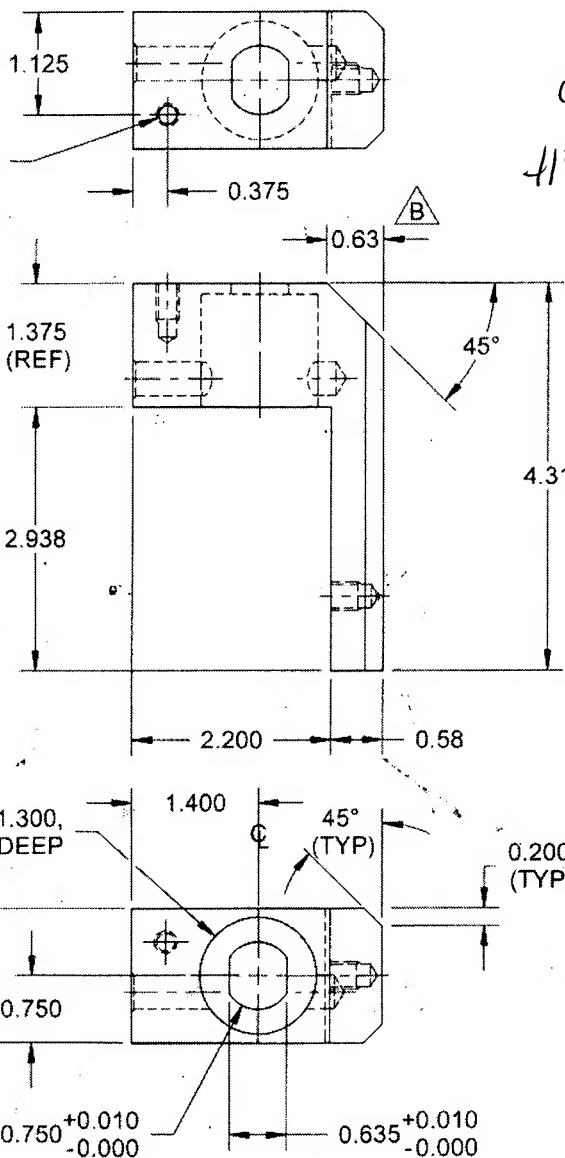
RELEASED
05/04/23

up
41526

2 DRILL $\phi 0.201$ x 0.600 DEEP
TAP 1/4-20 UNC x 0.400 DEEP

2 DRILL $\phi 0.377$,
2.363 DEEP.
CHAMFER 0.031 x 45°

2 DRILL "I" DRILL
x 0.525 DEEP
THREAD 5/16-24 UNF
x 0.300 DEEP



D3372-1 MAIN BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD		Work Order: 41526
Description: Main Body		Part Number: D3372-1
Inspection Dwg: D3372	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.377	+0.005/-0.000	0.380	✓			
0.313	+/-0.010	0.315	✓			
0.750	+/-0.010	0.744	✓			
1.375	+/-0.010	1.377	✓			
2.938	+/-0.010	2.937	✓			
0.575	+/-0.010	 	 			
2.200	+/-0.010	2.200	✓			
4.31	+/-0.030	4.316	✓			
1.50	+/-0.030	1.486	✓			
Ø1.300	+0.005/-0.000	Ø1.300	✓			
1.400	+/-0.010	1.398	✓			
0.635	+0.010/-0.000	0.636	✓			
0.750	+/-0.010	0.745	✓			
0.200	+/-0.010	0.198	✓			
Ø0.750	+0.010/-0.000	Ø0.750	✓			
4.100	+/-0.010	 	 			

Measured by: H.A	Audited by: SD	Prototype Approval: N/A
Date: 08/08/30	Date: 08/10/11	Date: N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	



W/O:		WORK ORDER CHANGES					
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